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TITLE: LASER BEAM **WELDING** HEAD
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INVENTOR-INFORMATION:

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ABSTRACT:

PURPOSE: To provide a laser beam **welding** head responding to a prescribed important matter by eliminating a defect of a **welding** nozzle.

CONSTITUTION: This **laser** beam **welding** head is provided with a nozzle 10 having an extremely small outlet diameter (d), (d) is 2.5 mm in the case of a CO₂ **laser** beam 6 having the **focal distance of 150 mm**, the nozzle 10 is provided with a conical inner surface 11, the half angle in the apex is 15 degrees in the case of the **laser** beam 6, the surface state being Ra 0.8 is also excellent, and an outlet zone is provided with a shelf part having the radius(r) nearly

equal to two times the nozzle outlet diameter(d).

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